

Date: Tuesday, 4/17/2007 11:08:50 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FWD TUBE ASSEMBLY	
Job Number	31849				
Estimate Number	10467				
P.O. Number	N/A		Part Number	D3391021	
This Issue	4/17/2007	S.O. No. N/A	Drawing Number	D3391 REV.F	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	F	
Previous Run	31810		Material	N/A	
Written By	[Signature]		Due Date	5/10/2007	Qty: 1 Um: Each
Checked & Approved By	[Signature]				
Comment	Est. A 05.09.13 New issue KJ/JLM Est. B 06.02.10 Dwg rev.D ecn 773 EC Est. C 06.05.02 Added inspections EC est D 07.03.13 rev F dwg EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D6013047	SKIDTUBE MAT'L
-----	----------	----------------



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description
1	D6013-047	Extrusion

Batch

B 26547 BE 07-04-19

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1  
 Cut extrusion to 46.52 +0.010 -0.020

BE 07-04-19

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: Nc bender  
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-5-7

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-8

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. F  
 Identify as D3391-1

2-Deburr

J.F. 07/05/16

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:08:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/05/16

①

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

BG 07-05-22

①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 07-05-22

①

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 07/05/22

①

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c'sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr

DD  
7-5-23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.A. 05-25-22

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Up 7-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/17/2007 11:08:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m-l* 07/07/19 ①

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR/m-l* 07-07-19 ②

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL* 07/07/23 ①

16.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivnut

Pick:

Qty  
*20*

Part Number

NAS1330C3KB166

Description

Insert

Batch

*M102849*

*m-l*

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

*m-l* 07/07/23 ①

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Er* 07/07/23 ②

19.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

1

Part Number

D3401-041

Description

Tow Cap

Batch

*B31346*

07/07/24

*m-l*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/17/2007 11:08:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D356413

WEARSHOE



*m.d*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

*B 31347*

21.0

D356613

GASKET



*m.d*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET

*B 31399*

22.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Bolt  
Pick:  
Qty Part Number Description Batch  
4 AN3C4A Bolt

*M104955*

*m.d*

23.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
Pick:  
Qty Part Number Description Batch  
4 NAS1515H3L Washer

*M104603*

*m.d*

24.0

AN960C10L

washer



*m.d*

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
washer

*M103057*

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*①*

Comment: SMALL & MEDIUM FAB RESOURCE 1  
Install tow Cap as per Dwg D3391  
Identify as D3391-021

*M.A*

*07/07/24*

26.0

QC5

INSPECT WORK TO CURRENT STEP

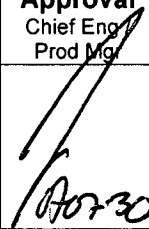



*(Pto) →*

Comment: INSPECT WORK TO CURRENT STEP  
Inspect thread of each insert using DT8821

*Inspect to current step for 30*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector	
07/07/24	26.0	Change step 26.0 to inspect to current spec	En	07/07/24				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/07/24

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 4/17/2007 11:08:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP

33526

6/7/30

28.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

DATA/31

Job Completion



u of of-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

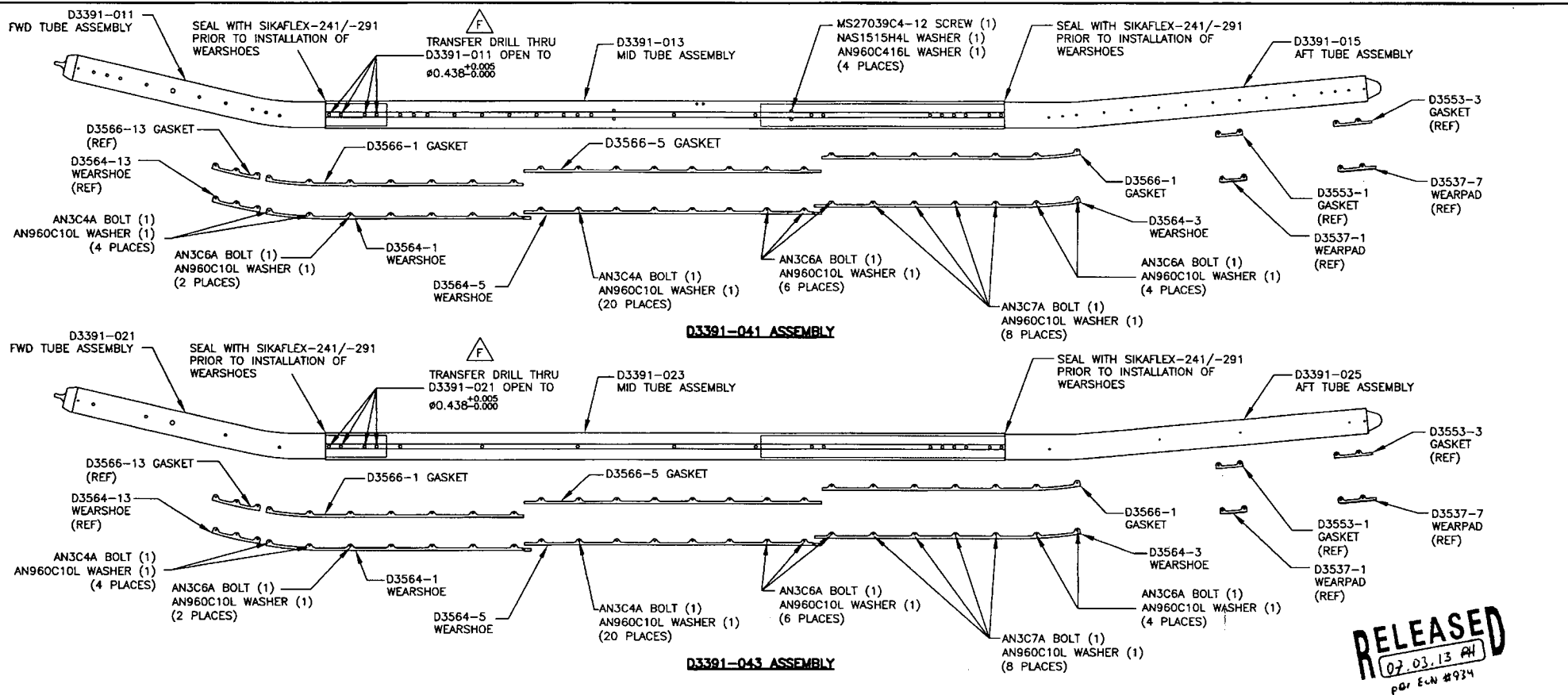
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

#### GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (0.250-0.257) FOR WEARSHOE INSERTS. C'SINK 0.391/0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

NO. 31849  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE

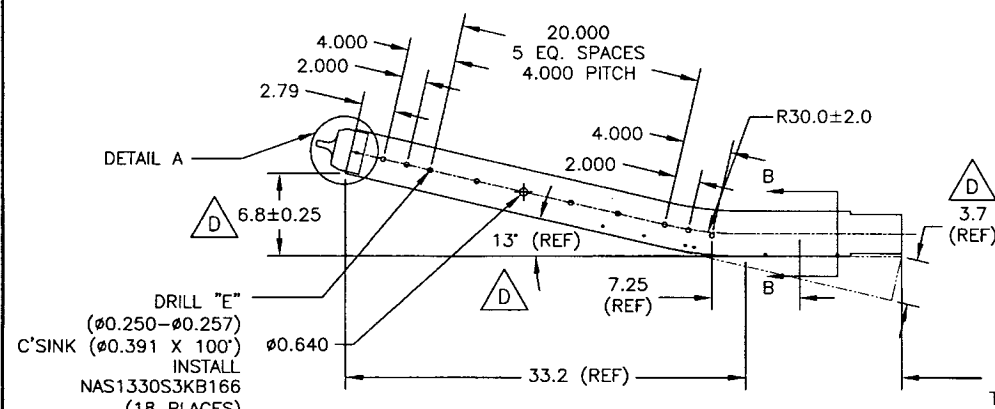
DART DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

DRAWING NO. D3391  
REV. F  
SHEET 1 OF 5  
SCALE  
NTS

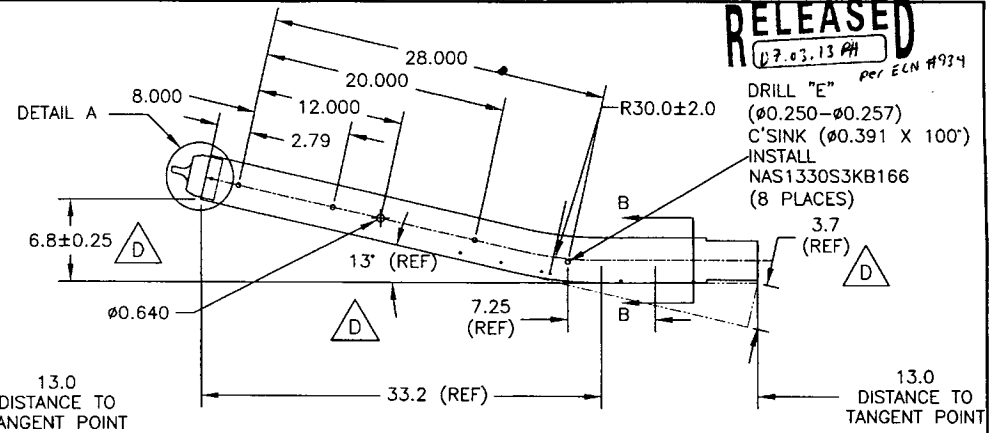
RELEASED  
07.03.13 AH  
per EUN #934

**RELEASED**  
D7.03.13 AH

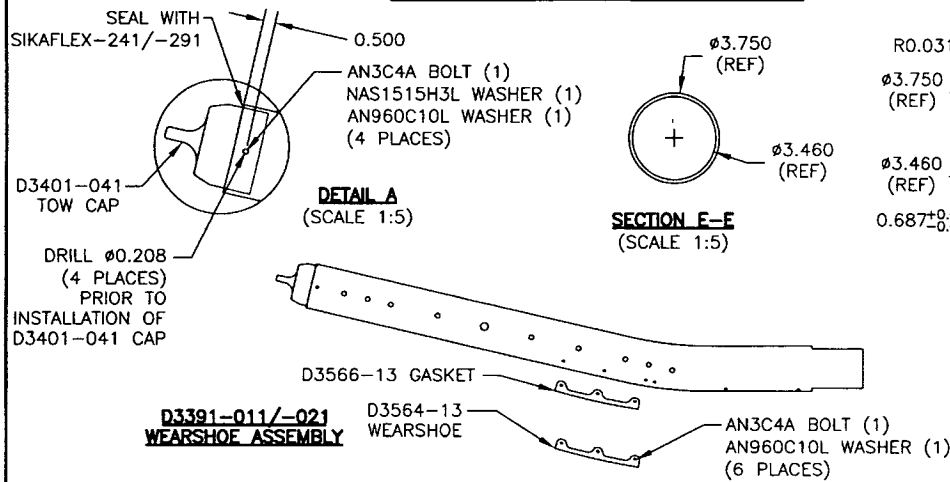
per ELN #974



**D3391-011 ASSEMBLY AND BENDING DETAIL**



**D3391-021 ASSEMBLY AND BENDING DETAIL**

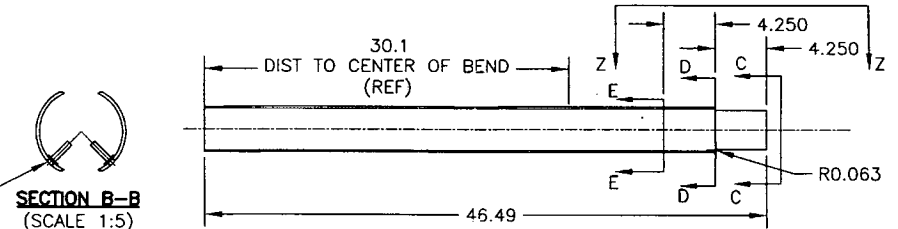


**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

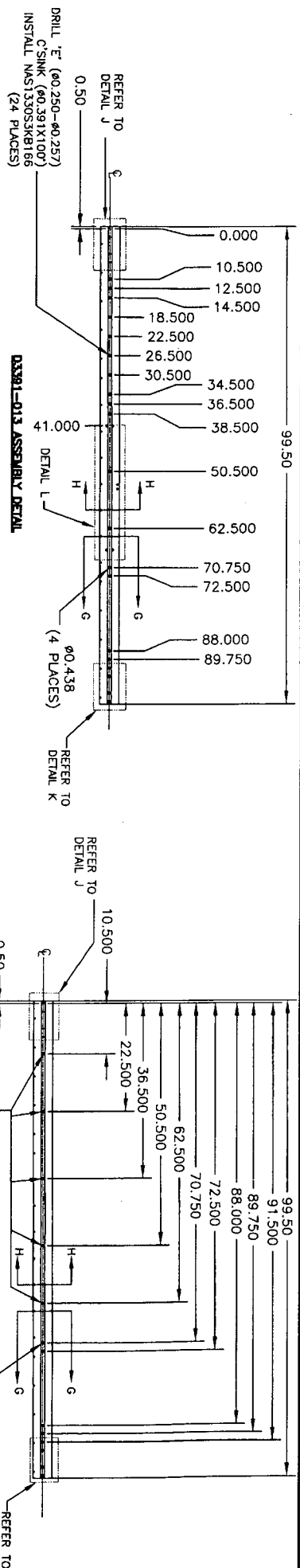
5  
DRILL "E"  
(Ø0.250-Ø0.257)  
C'SINK (Ø0.391 X 100')  
INSTALL  
NAS1330S3KB166  
(12 PLACES)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
318229

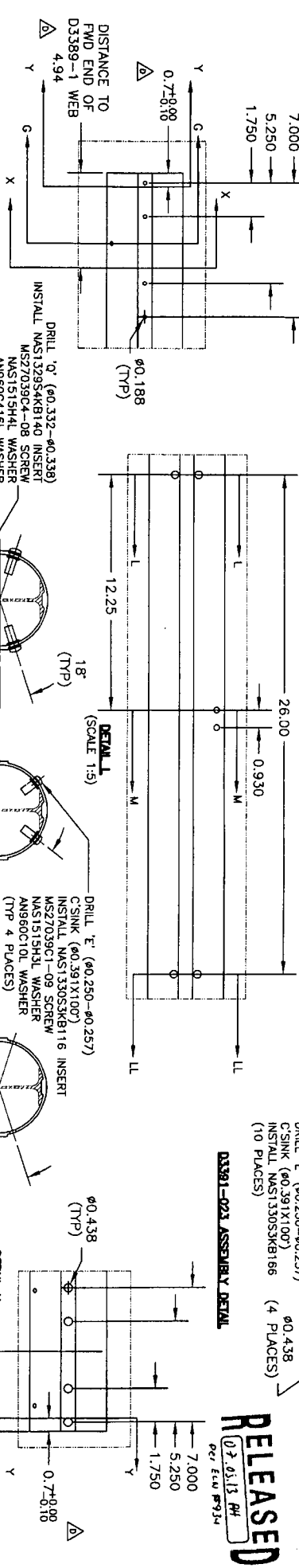


**D3391-1 DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.		DESIGN PH	DRAWN BY AH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED A	APPROVED A	DRAWING NO. D3391
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 2 OF 5 SCALE 1:10



D3391-013 ASSEMBLY DETAIL



D3391-023 ASSEMBLY DETAIL

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	QTY -	PART NUMBER	DESCRIPTION
013	023		
X	X	D3391-013	MID TUBE ASSEMBLY
X	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3K8116	INSERT (ØR NAS1330C3K8116)
24	10	NAS1330S3K8166	INSERT (ØR NAS1330C3K8166)
4	4	NAS1515H4L	WASHER
4	4	AN960C10L	WASHER
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER
4	4	MSZ7039C1-09	SCREW
4	4	MSZ7039C4-08	SCREW

SECTION L-L (SCALE 1:4)

SECTION M-M (SCALE 1:4)

SECTION N-N (SCALE 1:4)

SECTION O-O (SCALE 1:4)

SECTION P-P (SCALE 1:4)

- D3391-013/-023 MID TUBE ASSEMBLY
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKATEX-241/-291 PER OSI 015

WORK ORDER  
318497  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
REMOVE 0.030  
FROM TOP AND BOTTOM  
FROM TOP AND BOTTOM  
TO 3.610  
(0.7 FROM BOTH ENDS)

Copyright © 2006 by DART Aerospace USA, Inc.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE RELEASED FOR ANY PURPOSE WITHOUT WRITTEN PERMISSION FROM DART Aerospace USA, Inc.

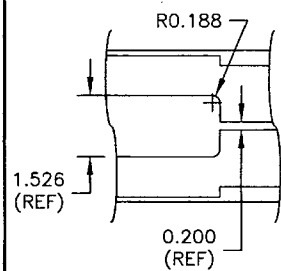
DESIGN	DRAWN BY	DATE	TITLE
PH	PH	07.01.18	412 FLOAT SKIDTUBE

REVISIONS

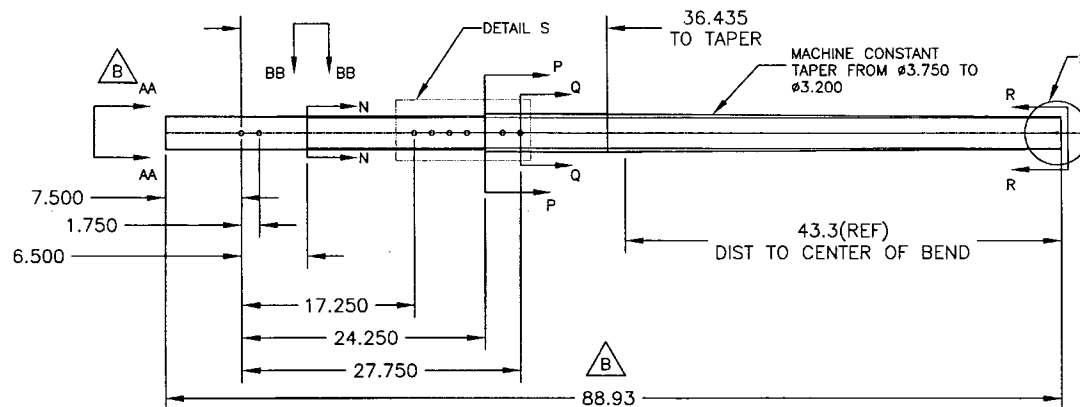
NO.	DATE	DESCRIPTION
1		

SCALE: 1:20

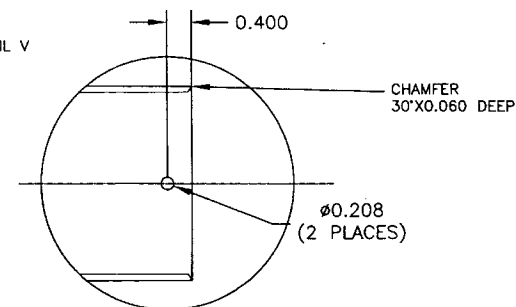
RELEASED  
03.05.13  
PER ECU 09324



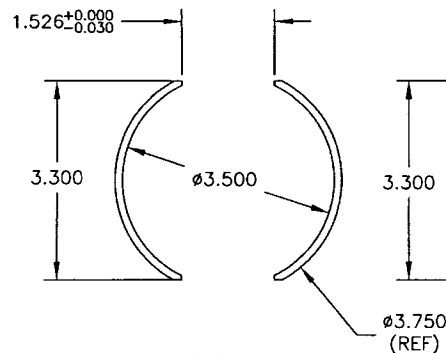
VIEW BB-BB  
(SCALE 1:3)



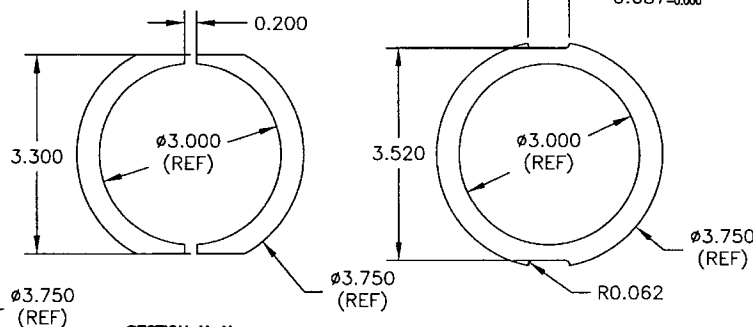
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



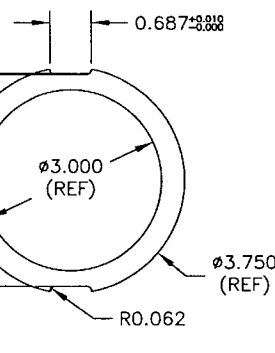
DETAIL V  
(SCALE 1:2)



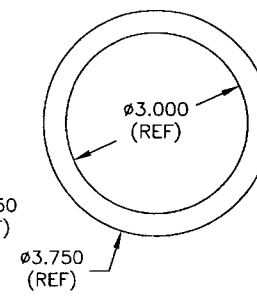
SECTION AA-AA  
(SCALE 1:2)



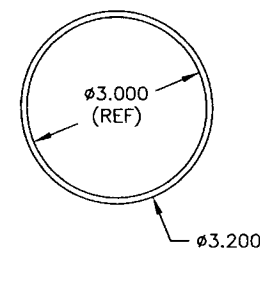
SECTION N-N  
(SCALE 1:2)



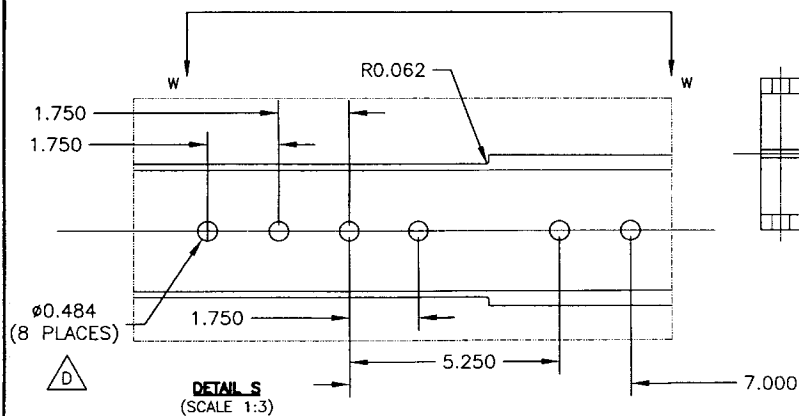
SECTION P-P  
(SCALE 1:2)



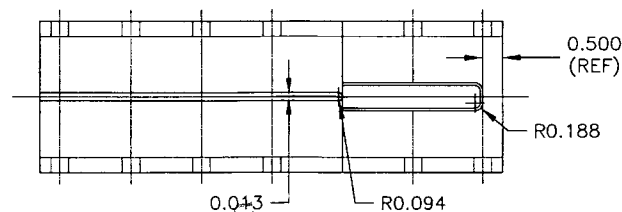
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)



VIEW W-W  
(SCALE 1:3)

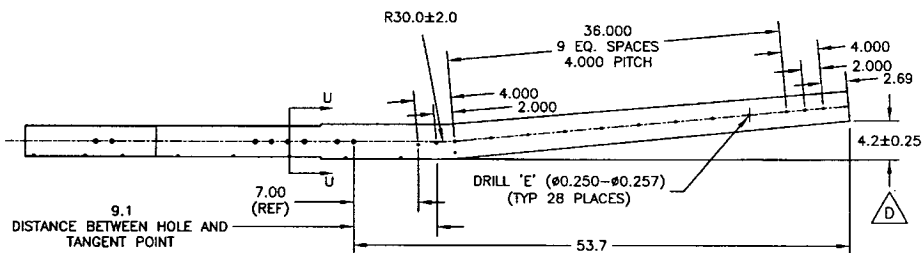
NO. 31845  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
CONTROLLED COPY  
RETURN TO  
SHOP COPY  
ENGINEERING

RELEASED  
07-03-13 PH  
P.C. E.C.N. #934

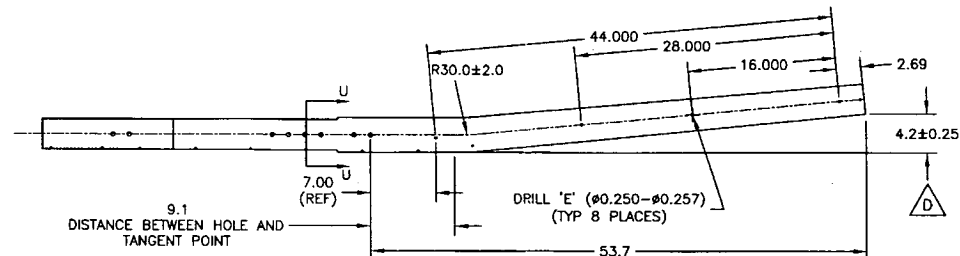
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

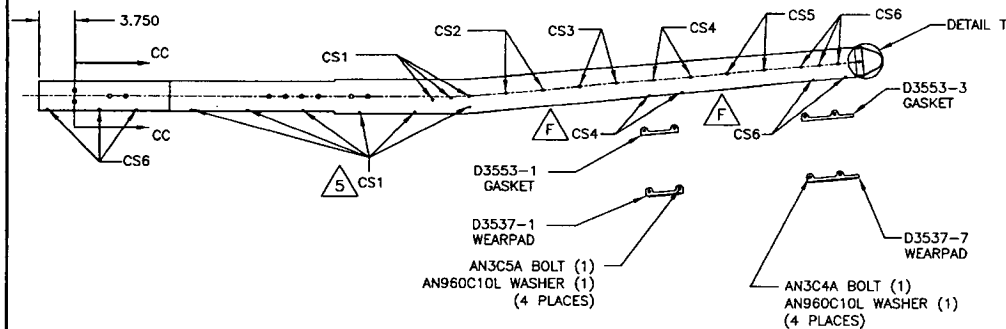
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



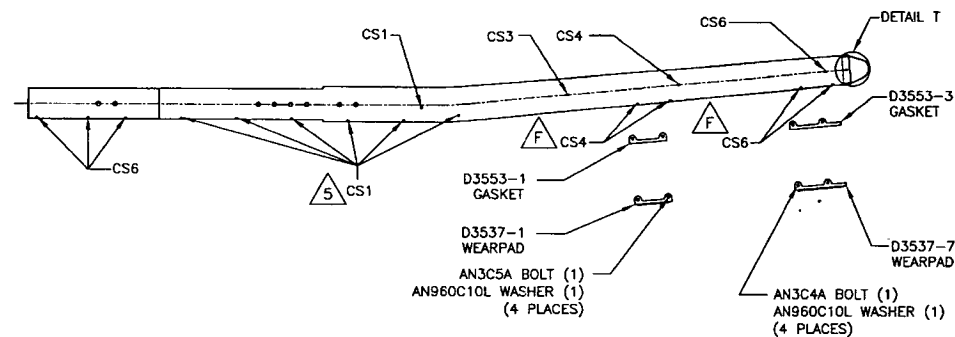
**D3391-015 BENDING AND ASSEMBLY DETAIL**



**D3391-025 BENDING AND ASSEMBLY DETAIL**



**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



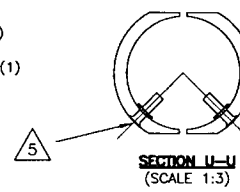
**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

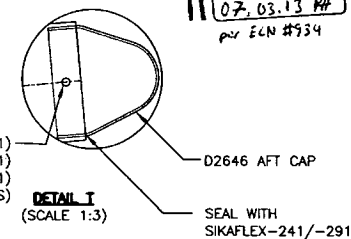
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	2	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	2	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

WORK ORDER  
 NO. 31849  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 ENGINEERING  
 SECTION CC-CC  
 (SCALE 1:3)

DRILL 'Q' (Ø0.332-Ø0.338)  
 C'SINK (Ø0.529X100")  
 NAS1330S4KB151 INSERT (1)  
 (4 PLACES)



AN3C4A BOLT (1)  
 NAS1515H3L WASHER (1)  
 AN960C10L WASHER (1)  
 (2 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
 AND IS SUPPLIED ON THE EXPRESS CONDITION  
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
 OR COPIED OR COMMUNICATED TO ANY OTHER  
 PERSON WITHOUT WRITTEN PERMISSION FROM  
 DART AEROSPACE USA, INC.

DESIGN PH	DRAWN BY BL	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED H	APPROVED H	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

RELEASED  
 07.03.13 RH  
 per EUN #734



